

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 82.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026973**Date Inspected:** 29-Dec-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**Contractor:** Westmont Industries**Location:** Santa Fe Springs, CA

| | | | |
|------------------------------------|--------------|----|-----|
| CWI Name: | Chris Concha | | |
| Inspected CWI report: | Yes | No | N/A |
| Electrode to specification: | Yes | No | N/A |
| Qualified Welders: | Yes | No | N/A |
| Approved Drawings: | Yes | No | N/A |

| | | |
|----------------------------------|-----|--------|
| CWI Present: | Yes | No |
| Rod Oven in Use: | Yes | No N/A |
| Weld Procedures Followed: | Yes | No N/A |
| Verified Joint Fit-up: | Yes | No N/A |
| Approved WPS: | Yes | No N/A |
| Delayed / Cancelled: | Yes | No N/A |

Bridge No: 34-0006**Component:** Maintenance Travelers**Summary of Items Observed:**

On this date, Caltrans Quality Assurance Inspector (QA) Sherri Brannon is present at the Westmont Industries (WMI) jobsite in Santa Fe Springs, California for the purpose of observing fabrication and QC functions for the SAS Superstructure, Bid Item #99, Maintenance Traveler and Bid Item #100, Maintenance Traveler (Bike Path).

This QA Inspector was informed by WMI Mr. George Grayum that WMI had received some miscellaneous materials for the Travelers. Mr. Grayum presented QA with material test report. QA Inspector reviewed Material Test Reports (MTR's) and checked physical condition of the components to be used for this project, verifying heat number and quantity. Materials inspected contained heat numbers as well as dimensions and material type. Details of materials inspected and approved for use on this project are listed below. QA Inspector issued Caltrans lot number B208-042-11 for OK to cut components and on the MTR as authorization and materials traceability purposes. The test results and conclusions indicated herein were based on random inspections and observations as described in this report. These documents are included as part of this report. Note: Domestic materials.

Materials Inspected & Approved (OK to Cut B208-042-11)

MATERIAL DESCRIPTION – angle- 6” x 3-1/2” x 5/16” x 20’ – ASTM A36

HEAT No. / MFR – L80168 / ArcelorMittal, Laplace, Louisiana

QUANTITY - 1 ea

E2/E3 EB Traveler

This QA Inspector randomly observed WMI production fitter Mr. Cesar Canales WID #3195 performing layout and fit-up for welding piping brackets to the E2/E3 EB Traveler. No welding performed on the SAS-WB Traveler

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on this date.

SAS Travelers Supplementary Platforms

This QA Inspector made random shop observations and observed no fit-up performed on the SAS Travelers Supplementary Platforms Assemblies on this date.

RPI Coating (Blast and Paint)

This QA Inspector performed random shop observations and observed that RPI Coating is on site to continue coat applications on Maintenance Travelers. QA Inspector was informed by RPI Coating Quality Control (QC) Representative Mr. Preston Keen that RPI is going to sweep blast SAS EB/WB Balconies, Traveler Trolley Links, Anti-twist assemblies today. Later in the morning this QA Inspector randomly observed that RPI personnel performing abrasive blasting activities on the above mentioned components. Mr. Keen stated that RPI will not apply the Zinc Clad II plus prime coating the SAS EB/WB Balconies, Traveler Trolley Links, or anti twist beams today. QA Inspector informed to Mr. Keen that RPI will be proceeding at their own risk pending acceptance of the sample test results. Mr. Keen stated that he is aware the RPI is proceeding at their own risk. After sweep/spot blasting was completed, QA Inspector then observed Mr. Keen performing random surface profile checks on the sweep blasted base metal surfaces. This QA Inspector observed Mr. Keen utilizing a Testex Press-O-Film and a micrometer to perform the testing. During observation, this QA Inspector observed that the readings appeared to be 3.2 mils, 3.3 mils, and 3.5 mils. QA Inspector then observed Mr. Keen perform a test for soluble salts on the previously blasted base metal surface. Testing observed by QA Inspector appears to be in compliance with the contract requirements. Note #1: The SAS EB/WB Balconies had been previously abrasive blasted and prime coated, but due to balcony modifications, balconies were re-blasted. Note #2: The Traveler Trolley Links had been previously abrasive blasted, prime and top coated, but due to Traveler brake modification, links were re-blasted in preparation for welding.

Later in the shift, this QA Inspector randomly observed RPI Coating performing what appeared to be primer application activities within what appeared to be within an 8 hour time frame from the above mentioned sweep blasting activities. Environmental readings taken by RPI at the time of the coating application are as follows Air Temperature 47/80 F, Relative Humidity 52/48%, Wet Bulb Temperature 39/68 F, Dew Point 30/61 F and Surface Temperature 46/67 F.

This QA Inspector randomly observed RPI Coating personnel sanding dry spray or overspray on SAS WB Traveler fixed stairs middle section of the lower truss in preparation for testing and applying the mist/top coat application. QA observed RPI using 80grit sandpaper. After sanding was completed QA Inspector observed RPI Coating personnel water rinsing sections mentioned above with a minimum pressure of 35Mpa/5,077 PSI pressure washer.

QA Inspector sampled of parts A, part B, and part F, of Sherwin Williams Zinc Clad II Plus Inorganic Zinc-Rich Coating representing 1 kit. QA Inspector assigned Caltrans Lot #B208-044-11 and TL-101 # 712430.

This QA noted above items observed appear to comply with contract documents.

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Summary of Conversations:

As stated within this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910 , who represents the Office of Structural Materials for your project.

Inspected By: Brannon, Sherri

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer